

HA7 - ABAP

Date: Monday, 22/12/2008 2:09:06 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B BASKET BASE
Job Number	: 44222B		
Estimate Number	: 11276		
P.O. Number	:	Part Number	: D2330041
This Issue	: 22/12/2008 S.O. No. :	Drawing Number	: D2330 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: F
Previous Run	: 40843B	Material	:
Written By	:	Due Date	: 15/01/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 08-12-23</u>		
Comment	: Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J Est Rev:l 08-09-09 revF as per dwg (ecn 08-522) DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part# Description Batch 4 D3166-1 Hoop <u>L14050</u> <u>SAD 08-01-23</u> ①		
2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
Comment: Qty.: 26.3970 f(s)/Unit Total : 26.3970 f(s) 3/4" x 3/4" x 0.065 wall 304/316 SS tubing. Batch: <u>M116335</u> <u>SAD 09-01-16</u>		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Cut 4 D2235-1 From D3166-1 2- Cut D2330-1-3-5-7-9 as per Dwg D2330 3-Drill hole in D2330-3 as per Dwg D2330 4-Deburr <u>SAD 09-01-16</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 44222B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D22531

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gusset

✓ Batch: B 40894 → 2x

SL 09/01/21

5.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

* Qty Part Number Description Batch
1 D2012-107 Clevis B 40274 → 1x

SL 09/01/21

6.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
1 D2327-3 Bushing B 39560 → 1x

SL 09/01/21

7.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
4 D2581 Mounting Chanel B 43800 → 4x

SL 09/01/21

8.0

D2254

Gussett



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 D2254 Lug B 39801 → 2x

SL 09/01/21

9.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 D2232-3 HINGE B 42075 → 2x

SL 09/01/21

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 44222B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 31.5000 sf(s)/Unit Total: 31.5000 sf(s)

Pick:

Qty Part Number Description Batch

30 sf M304EX0.75-16F Expanded Metal M110134

SAD 09-01-20

⑧

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330, using Welding Table and corner Jig/Debur as required

A/R SS ROD Batch: M108775

SY 09/01/22

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-26 ①

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/26 ②

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:45

OVEN TEMPERATURE: 400°

FINISH TIME: 9:15

M109996

FL 09/01/28

③

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AS

09-01-28 ④

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

44222 W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/02 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.06.30 00579

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D2330-041	BASKET ASSEMBLY
	X	D2330-043	LID ASSEMBLY
1		D2012-107	CLEVIS
	2	D2232-1	HINGE
2		D2232-3	HINGE
4		D2235-1	RIB
2		D2253-1	LUG
2		D2254	GUSSET
	1	D2327-1	BUSHING
1		D2327-3	BUSHING
	1	D2329	LABEL PLATE
2		D2330-1	FRAME
2	2	D2330-3	FRAME
1		D2330-5	FRAME
1		D2330-7	FRAME
1	2	D2330-9	FRAME
	2	D2330-11	FRAME
	2	D2330-13	FRAME
	1	D2330-15	FRAME
4	2	D2581	MOUNTING CHANNEL

RELEASED
08-09-11

F

NOTES:

FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065

MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: N/A

WELD PER DART QSI 004

REFERENCE ONLY

44222B

F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2330	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

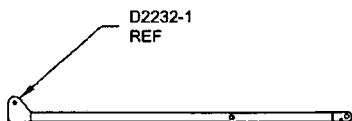
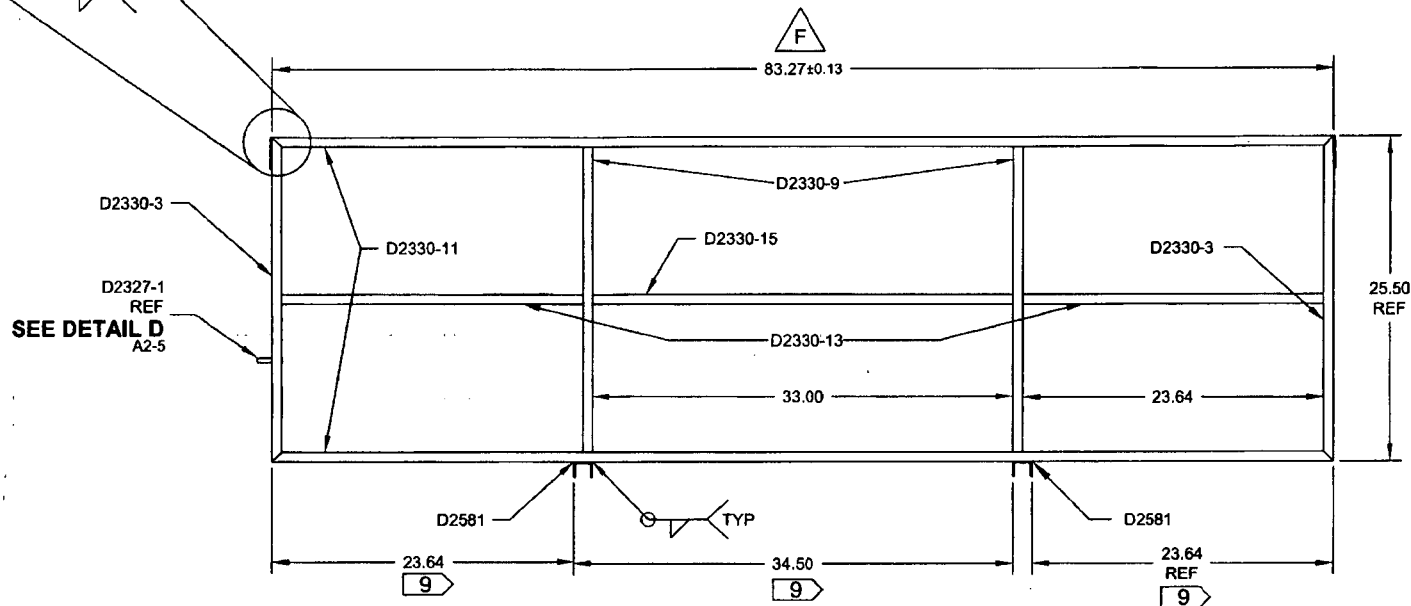
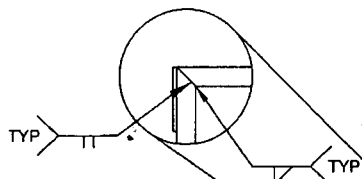
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NOTE: Date & initial all entries

WELD ALL JOINTS
AS SHOWN



LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE



REFERENCE ONLY

44222B

D2330-043 LID FRAME

RELEASED
08-07-25-11

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	ALIS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2330	SHEET 2 OF 6
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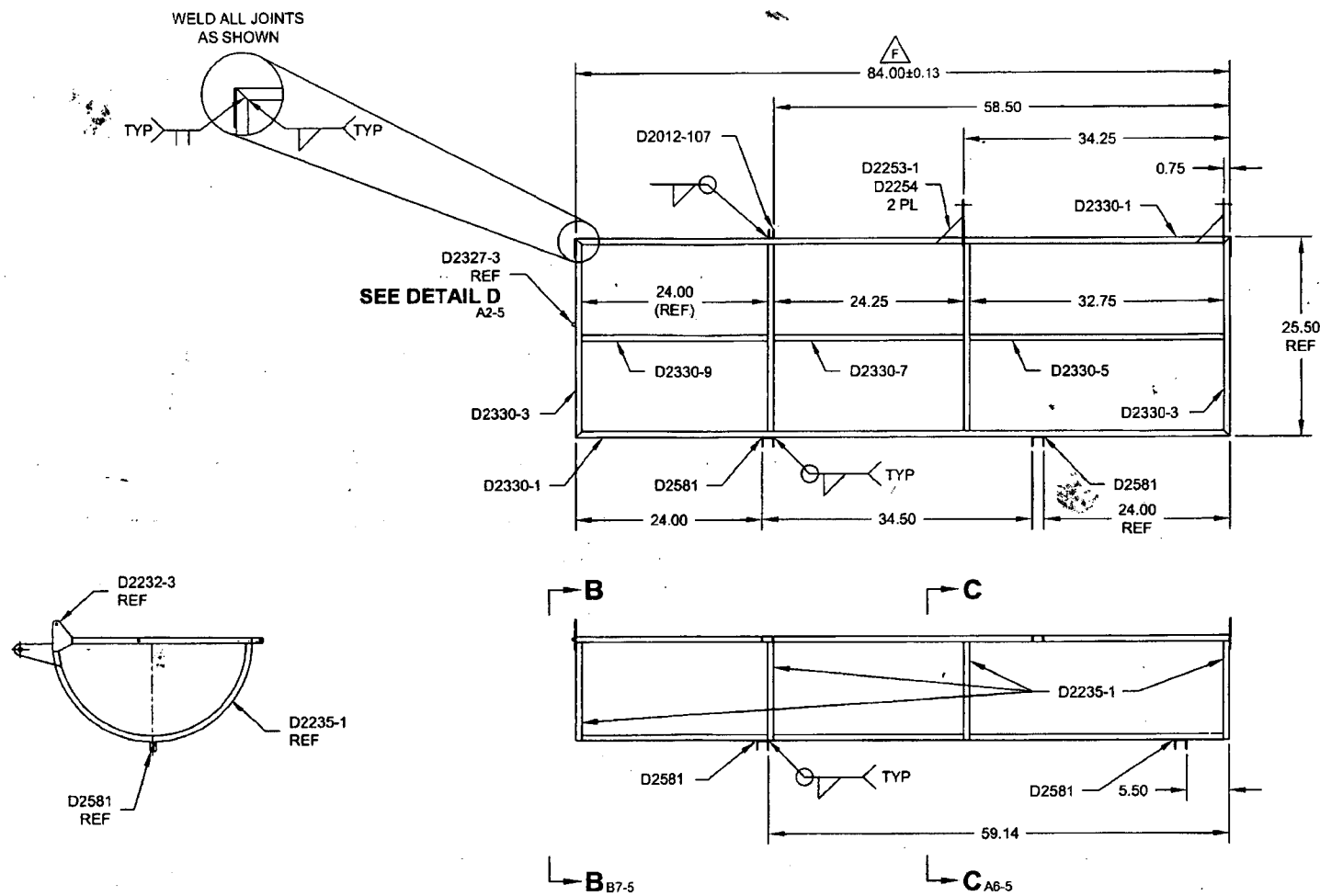
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



RELEASED
08-09-05/11

D2330-041 BASE FRAME ASSEMBLY

BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

REFERENCE ONLY

44222B

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2330	SHEET 3 OF 6
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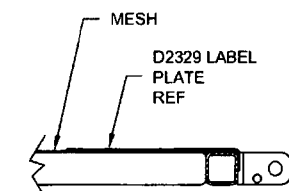
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

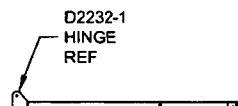
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

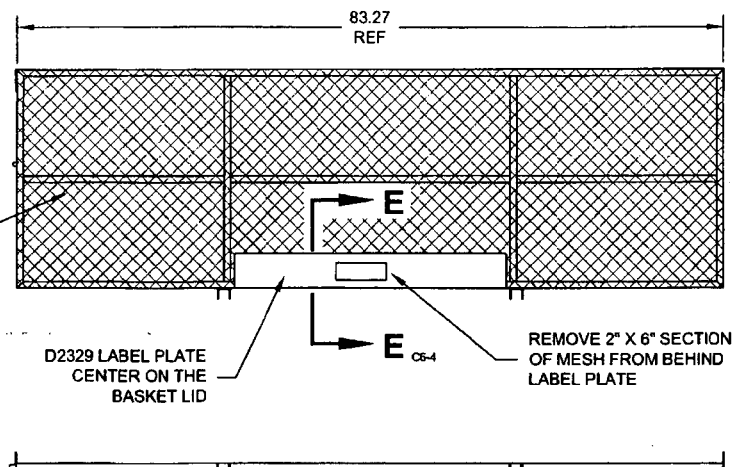
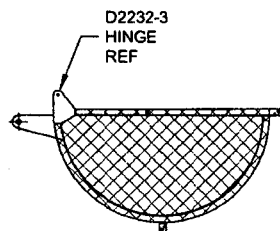
NOTE: Date & initial all entries



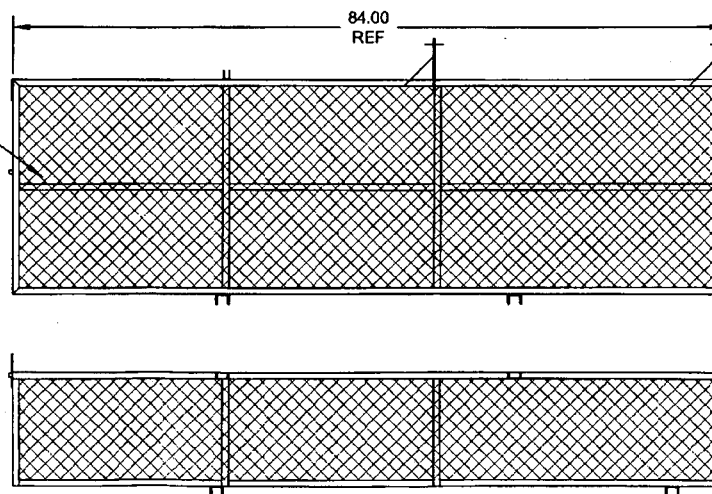
SECTION E-E C3-4
VIEW ROTATED 90° CCW



TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME



D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY

RELEASED
08-09-05-11

ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

REFERENCE ONLY

44222B

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. F
MFG. APPR.	JB	D2330	SHEET 4 OF 6
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	BASKET ASSEMBLY (206B)	NTS
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W/O:		WORK ORDER CHANGES					
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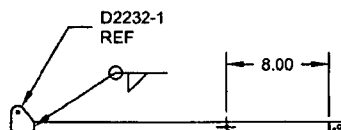
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

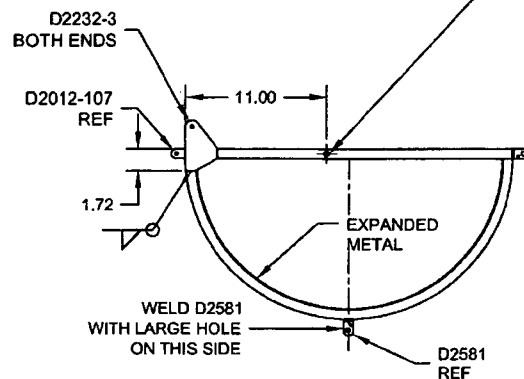
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

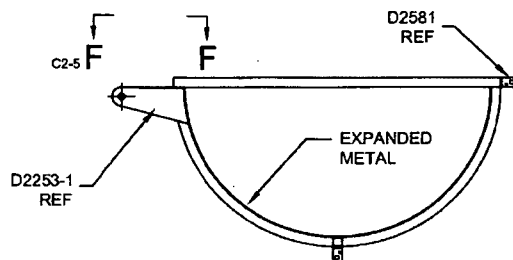


VIEW A-A A6-2

DRILL 3/8 HOLE AND
INSTALL D2327-1/-3
SEE DETAIL D A2-5



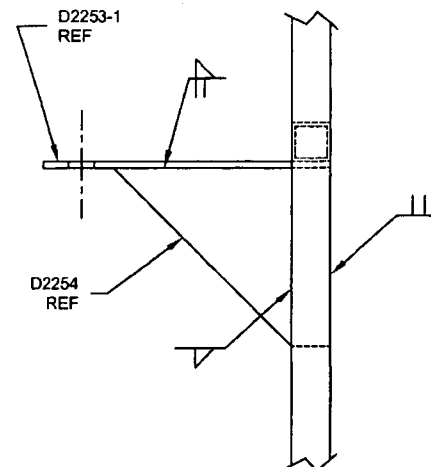
VIEW B-B A5-3



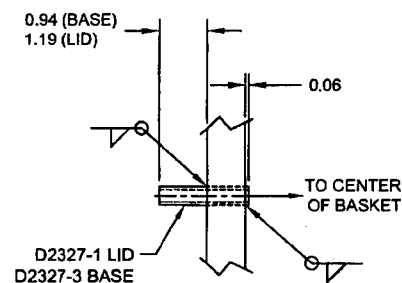
VIEW C-C A3-3

REFERENCE ONLY

44222B



VIEW F-F B8-5
SCALE 4X



DETAIL D
SPACER INSTALLATION
SCALE 4X

C6-2
C5-3
C6-5

RELEASE
18 08 11

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D2330	SHEET 5 OF 6
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8 7 6 5 4 3 2 1

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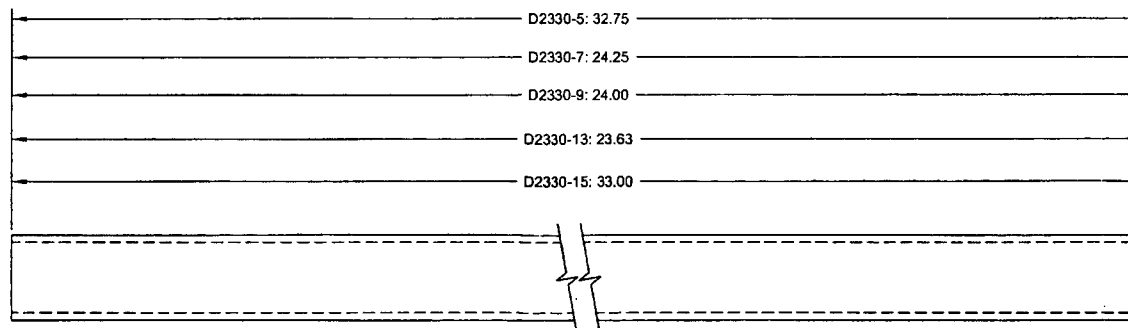
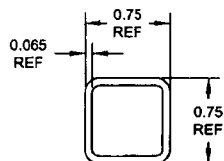
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8 7 6 5 4 3 2 1



D2330-5 FRAME

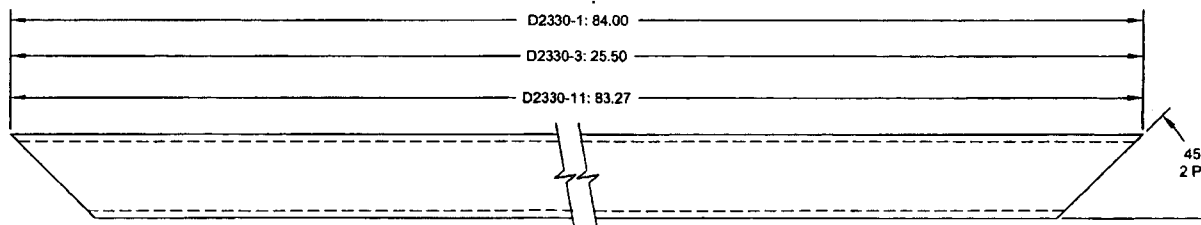
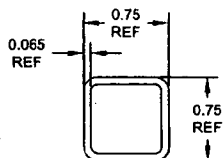
D2330-7 FRAME

D2330-9 FRAME

D2330-11 FRAME

D2330-13 FRAME

D2330-15 FRAME



D2330-1 FRAME

D2330-3 FRAME

D2330-11 FRAME





RELEASED
68-09-05 10

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

REFERENCE ONLY

44222B

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2330	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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8 7 6 5 4 3 2 1

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